

Work Order ID 127964

127964

Page 1

Item ID: D5101-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Insert

Stop *NS2*

Start Date: 12/18/14 Start Qty: 160.00

160

Cust Item ID:

Required Date: 1/05/15 Req'd Qty: 160.00

160

Customer:

Reference:

Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5101									

100

0.00

100

Hardinge CNC LATHE SMALL

Doosan

Memo

0.00

Doosan Lathe

 TURN AS PER FOLIO FB 357
 FOLIO REV: N/A
 DWG REV: A

DEBURR

 DAS
 25
 9-89

15-1-4

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

 DAS
 25
 9-89

15-1-4

Work Order ID 127964

127964

December-18-14 11:50:53 AM

Page 2

Item ID: D5101-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Insert
 Start Date: 12/18/14 Start Qty: 160.00 ***160*** Cust Item ID:
 Required Date: 1/05/15 Req'd Qty: 160.00 ***160*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120						160			BC
QC	Memo	0.00							15-01-05
Quality Control									
130	Chemical Conversion Coat per QS1005 4.1	0.00							
130						160		15-1-5	12/18/14
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150						160			DAS
QC	Memo	0.00							38
Quality Control									9-89

JAN 05 2015

Work Order ID 127964

December-18-14 11:50:53 AM

127964

Page 3

Item ID: D5101-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Insert
Start Date: 12/18/14 Start Qty: 160.00 ***160*** Cust Item ID:
Required Date: 1/05/15 Req'd Qty: 160.00 ***160*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>S147</u>	0.00							
160									
Packaging	Memo	0.00				(160x)	DAS 46		JAN 06 2015
Packaging							9-89		
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

15/1/16 *[Signature]*
mf
15-01-06

Picklist Print

December-18-14 11:50:53 AM

Page 1

Work Order ID: 127964

127964

Parent Item: D5101-3

D5101-3

Parent Item Name: Insert

Start Date: 12/18/14

Required Date: 1/05/15

Start Qty: 160.00

Required Qty: 160.00

Comments: IPP REV:A NEW ISSUE 14-12-18 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6R0.750

Purchased

No

f

72.0000

8

M6061T6R0 750

**

JL 15-1-4

6061-T6 Round Bar .750"

Location

Loc Qty

Loc Code

MAT012

72

m130745

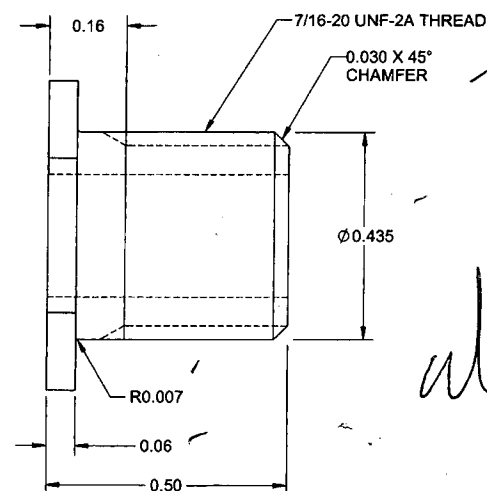
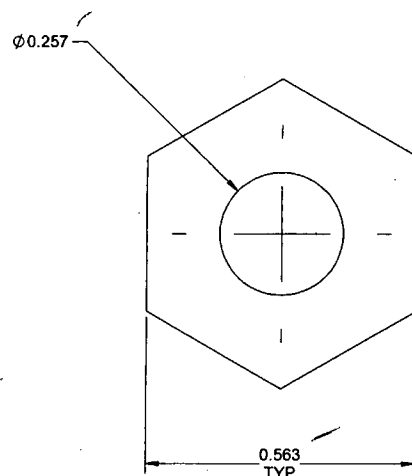
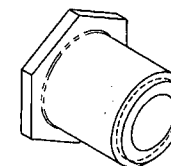
72

130527

1.98 x 30 pss

7.8

not in system



D5101-3 INSERT

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.005 lbs

W/O 127964

RELEASED

2014 NOV 24 *q*

APPROVED

DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5101	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CROSSBOLT SPACER	NTS
DATE	14.08.07	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	